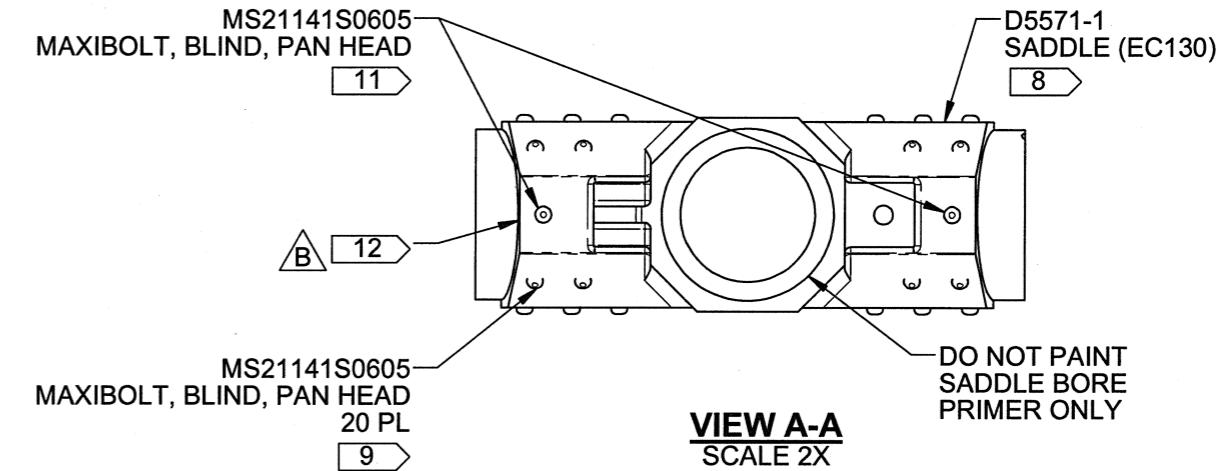
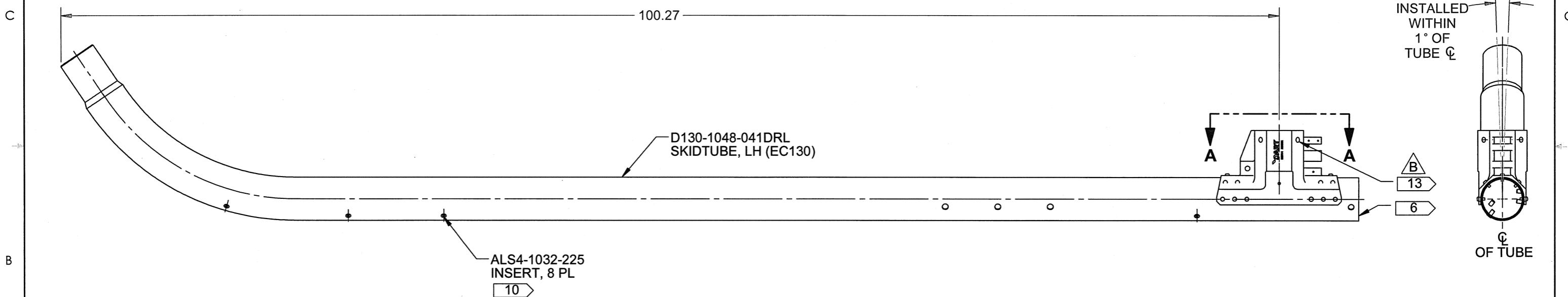


QTY -041	P/N	DESCRIPTION
X	D130-1048-041	SKIDTUBE ASSY, LH (EC130)
1	D130-1048-041DRL	SKIDTUBE, LH (EC130)
1	D5571-1	SADDLE (EC130)
22	MS21141S0605	MAXIBOLT, BLIND, PAN HEAD (CR7621S06-05)
8	ALS4-1032-225	INSERT



**VIEW A-A**  
SCALE 2X



### D130-1048-041 SKIDTUBE ASSY, LH (EC130)

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) AFTER ASSEMBLY  
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) AFTER ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D130-1048-041" AND S/N PER DART QSI 044 6.4  
ON INSIDE OF TUBE, MAX 0.5" FROM AFT END OF TUBE
- 7) WEIGHT: 20.29 lbs
- 8) SEAL FAYING SURFACE WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 9) POSITION SADDLE AND TRANSFER DRILL Ø 0.193 HOLE PATTERN FROM SADDLE ONTO SKIDTUBE.  
OPEN HOLES THRU SADDLE AND SKIDTUBE TO Ø 0.199 - Ø 0.202. TOUCH-UP HOLES WITH CHEMICAL FILM (ALODINE 1200)  
PER MIL-DTL-5541. WET INSTALL MAXIBOLTS WITH PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS A SEALANT
- 10) INSTALL ALS4 INSERTS IN EXISTING Ø 0.297 HOLES AFTER FINISH
- 11) TRANSFER DRILL Ø 0.193 HOLES FROM SADDLE TO SKIDTUBE. OPEN HOLES THRU SADDLE AND SKIDTUBE  
TO Ø 0.199 - Ø 0.202. ENSURE CLEAN HOLES FOR GOOD ELECTRICAL BONDING. TOUCH-UP HOLES WITH  
ELECTRICALLY CONDUCTIVE CHEMICAL FILM (ALODINE 600) PER MIL-DTL-5541. INSTALL MAXIBOLTS DRY (NO SEALANT)
- 12) FILLET SEAL ALL AROUND SADDLE WITH SIKAFLEX-241/-291 OR PROSEAL 890 OR EQUIVALENT MIL-S-8802 CLASS B SEALANT
- 13) MASK SADDLE HOLES BEFORE PRIME AND PAINT

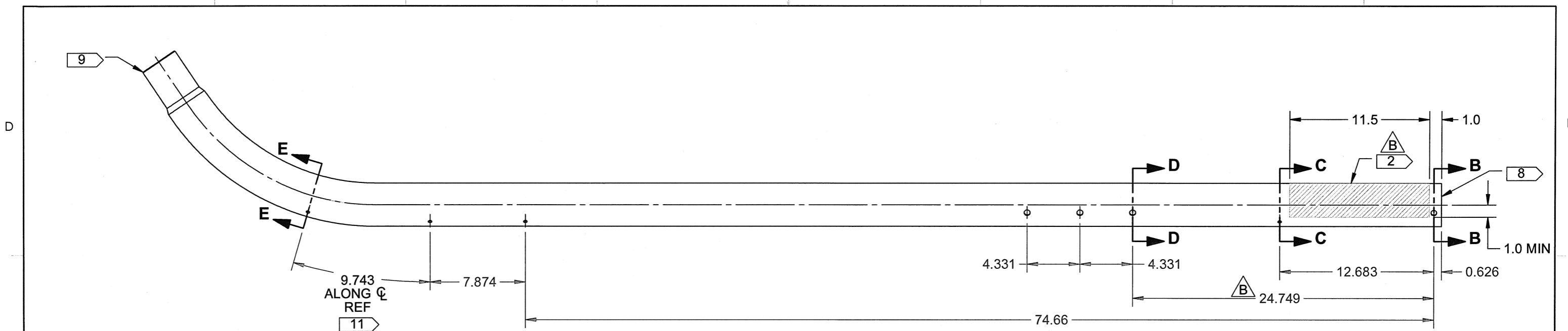
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2019 JUN 19 NO  
FCN 19-625

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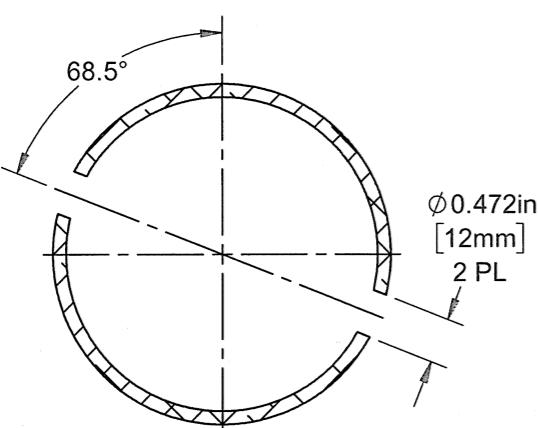
B	REDRAWN BOTH SHEETS, D130-1048-041: ADDED PRIME TO FINISH NOTE, ADDED CLASS A SEALANT FOR FAY SEAL AND WET INSTALL MAXIBOLTS, INSTALL ALS 4 INSERTS AFTER FINISH, ADDED NOTE 12. D130-1048-041DRL: PRIME IN AREA SHOWN WAS PRIME INSIDE AND OUTSIDE, LPI AFTER DRILLING WAS PRIOR TO DRILLING, ADDED NOTE 12, REDIMENSION FROM BLADE HOLE INSTEAD OF TUBE END	ZF	18.12.31
A	NEW ISSUE	ZF	18.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MW	DRAWING NO.	
MFG. APPR.	JFS	D130-1048-041	REV. B
APPROVED	NO	TITLE	SHEET 1 OF 2
DE APPR.	CP 91	SKIDTUBE ASSY, LH (EC130)	SCALE
DATE	18.12.31	NTS	

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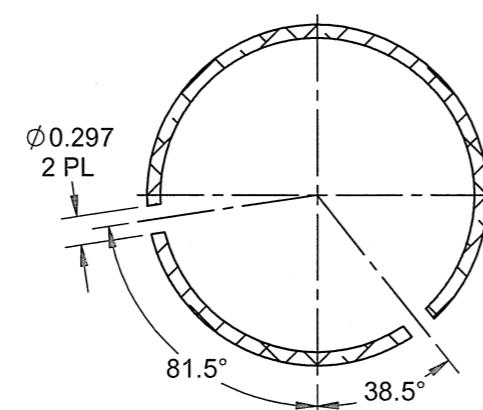


**D130-1048-041DRL SKIDTUBE, LH (EC130)**  
(DRILLING DETAIL)

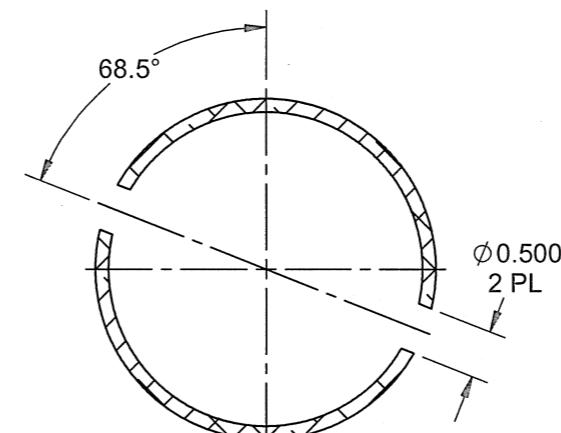
B



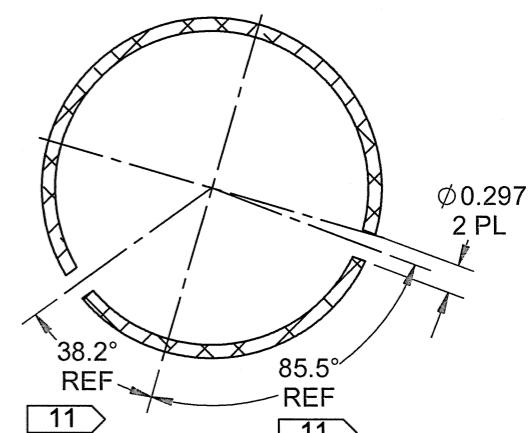
**SECTION B-B**  
SCALE 4X



**SECTION C-C**  
SCALE 4X, 3 PL



**SECTION D-D**  
SCALE 4X, 3 PL



**SECTION E-E**  
SCALE 4X

## NOTES:

1) MATERIAL: MAKE FROM D5611-1  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 PRIME AREA SHOWN (TO 1.0 BELOW CENTERLINE), PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 16.34 lbs  
 8) CHAMFER ID 0.06X0.06 WHERE INDICATED  
 9) CHAMFER OD 0.06X0.06 WHERE INDICATED  
 10) LIQUID PENETRANT INSPECT OUTSIDE SURFACE PER QSI 038 AFTER DRILLING.  
 11) LOCATE HOLES USING DRILLING JIG DT10431.  
 12) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.  
 THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, WRINKLES OR DENTS.  
 DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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2019 JUN 19 No

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DESIGN	NO	<b>DART AEROSPACE LTD</b>	
DRAWN	ZF	HAWKSLEY, ONTARIO, CANADA	
CHECKED	MW		
MFG. APPR.	JFS		
APPROVED	NO		
DE APPR.	CP	<b>D130-1048-041</b>	
DATE	18.12.31	REV. B	
		SHEET 2 OF 2	
		TITLE	
		<b>SKIDTUBE ASSY, LH (EC130)</b>	
		NTS	
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